

Date: Wednesday, 12/11/2008 1:37:41 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COMFORT SEAT- FRAME
Job Number : 43357	
Estimate Number : 13369	
P.O. Number :	Part Number : D37521
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3752
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : C
Previous Run : 42057	Material :
Written By :	Due Date : 08/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.11.12</u>	
Comment : Est. REV: A New Issue 08.06.03 DL verified by:DD Est Rev. B Dwg. Update 08/07/22 DL Est. Rev. C Dwg. Update Shorter length 08/10/28 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

Set up machine program D3752-1
 Set up clamping frame as per folio

OK 08/11/18

2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 10.6670 sf(s)/Unit Total : 10.6670 sf(s)
 GE PLASTICS LEXAN SHEET

Batch # M105330

BB 08/11/13 (X1)

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/11/13 (X1)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3752 and Folio

Dwg. Rev. C
 Folio Rev. C

BB 08/11/14 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COMFORT SEAT- FRAME

Job Number: 43357

Part Number: D37521

Job Number:



Seq. #:

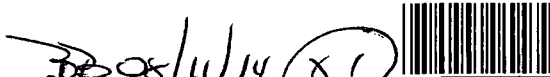
Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



BB 08/11/14 (X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/11/17 (X1)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 08/11/17 (X1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/17 (X1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

STQ63

SS 08/11/18 (X1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18 (X1)

Job Completion



MF 08-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		WORK ORDER:	43357
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg:	D3752	Rev:	C
			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	✓
Free of visual flaws (bumps, cracks, voids, etc.)	✓

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
0.028"	MIN	.034	✓			
0.035"	MIN	.047	✓			
0.040"	MIN	.072	✓			
0.075"	MIN	.108	✓			
0.052"	MIN	.102	✓			
0.021"	MIN	.061	✓			
0.036"	MIN	.081	✓			

Measured by: JRB	Audited by: S	Prototype Approval: 1
Date: 08/11/17	Date: 08/14/17	Date: 1/17

Rev	Date	Change	Revised by	Approved
		New Issue		

[Handwritten signature]

ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

OPTIONAL TOOLING HOLE, 0.028 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE, 0.035 MIN THICKNESS AT THIS LOCATION

0.040 MIN THICKNESS ALONG TOP EDGE

OPTIONAL TOOLING HOLE, 0.075 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE, 0.052 MIN THICKNESS AT THIS LOCATION

HEAVY HAIRCELL TEXTURE ON THIS SIDE

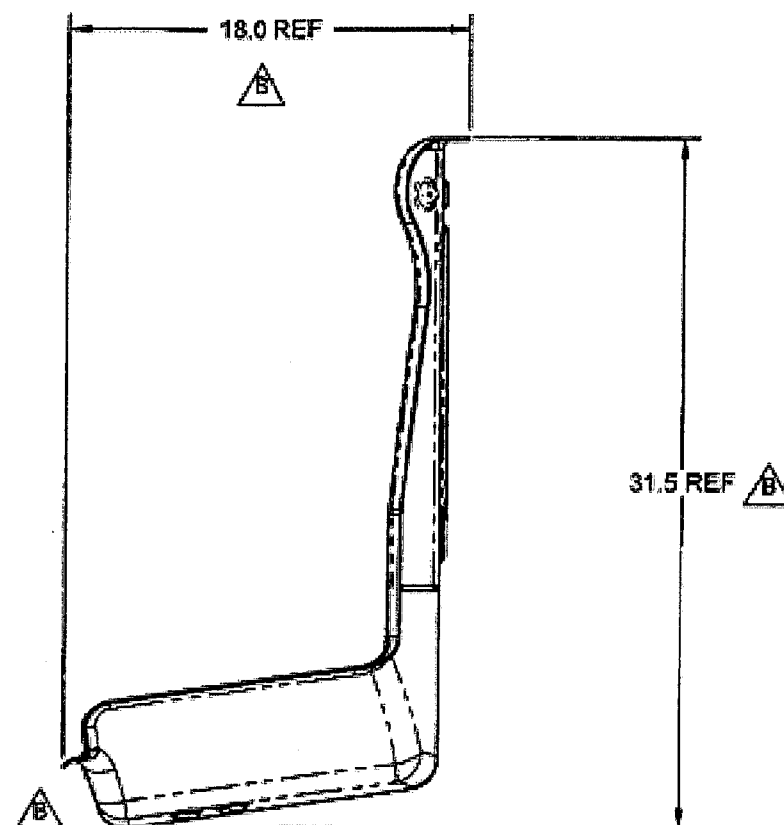
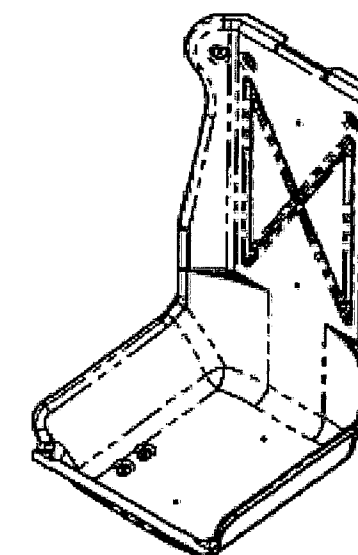
0.021 MIN THICKNESS IN THIS AREA (CORNER)

0.036 MIN THICKNESS ALONG BOTTOM EDGE

D3752-1 SEAT FRAME

NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.



RELEASED
08/11/05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43357

C	REDUCE THICKNESS: 0.040 WAS 0.050 (ZIN CB-1), 0.075 WAS 0.100 (CB-1), 0.052 WAS 0.090 (BB-1), 0.021 WAS 0.030 (BB-1), 0.036 WAS 0.050 (AB-1), 0.028 WAS 0.035 (DB-1), 0.035 WAS 0.050 (DB-1), SOME HOLES NOW OPTIONAL (AB-1 TO DB-1)	CP	08.10.08
B	FRONT PORTION NOW SHORTER (B5-1), 18.0 WAS 19.6 (C4-1), 31.5 WAS 30.3 (B3-1), ADD 4 HOLES FOR THICKNESS MEASUREMENT (D6-1, B8-1)	CP	08.09.08
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3752 TITLE SEAT FRAME REV. C SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			